


Date: Tuesday, 20/01/2009 2:32:09 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOUBLER	
Job Number : 44962		
Estimate Number : 13740		
P.O. Number :	Part Number : D38711	
This Issue : 20/01/2009 S.O. No. :	Drawing Number : D3871 PRELIM	
Prsht Rev. : NC	Project Number : N/A	
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : PRELIM	
Previous Run :	Material :	
Written By :	Due Date : 27/01/2009	Qty: 4 Um: Each
Checked & Approved By :		
Comment : Est Rev:A 09-01-19 as per prelim issue DD verified by:ec		

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S040	6061-T6 .040 Sheet
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Comment: Qty.: 0.1587 sf(s)/Unit Total : 0.6346 sf(s)
 6061-T6 .040 Sheet
 batch: 107461 HB 9-1-21

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3871-1
 Dwg Rev: PRE HB 9-1-21
 Prog Rev: Lim
 ****grain direction 45 degree****
 2-Deburr if necessary HB 9-1-21

(6)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

ENGINEERING APPROVAL

09.01.21 (6)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1- Bend as per Dwg D3871

SD 09/01/24

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 20/01/2009 2:32:09 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 44962

Part Number: D38711

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



ENGINEERING
PROVAL



Comment: INSPECT WORK TO CURRENT STEP

09/01/26 (6x)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M. 09/01/27

(6x)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FD 09/01/27 (6)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart P/N and B/N using a permanent fine point marker, then Stock

Location:

57/0 PPA 44962 09/01/27

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/18

Job Completion



POSITIVE RECALL

mf 09-01-28

EFFECTIVE

09/01/27

AUTH

RELEASED

DATE

09/02/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 44962
Description: DOUBLED		Part Number: D3871-1
Inspection Dwg: D3871-1, Rev: PRE L		Page 1 of 1

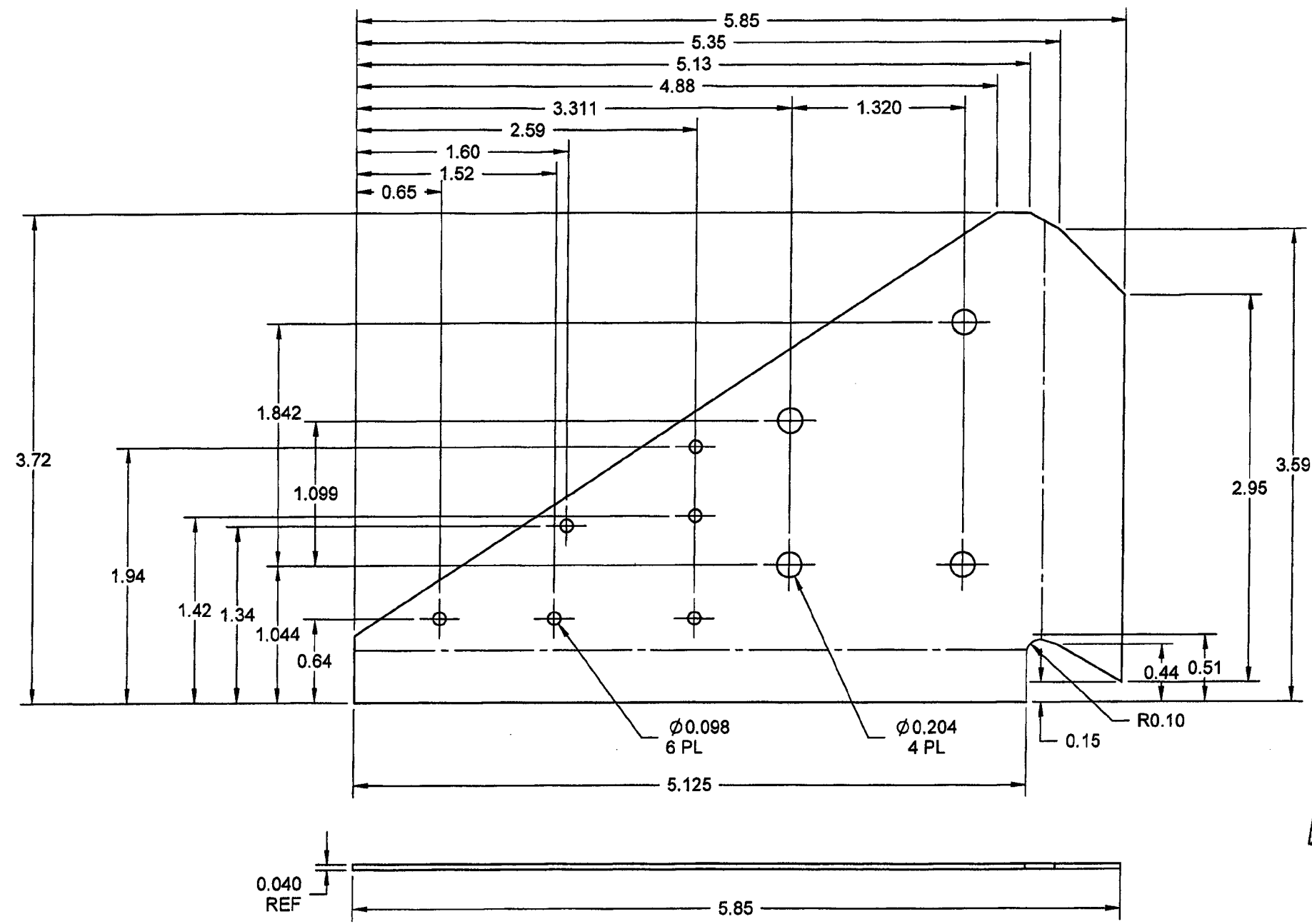
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+ .004 - .001	.101	✓			
Ø .204	+ .005 - .001	.209	✓			
.14	+/- .030	.1637	✓			
1.044	+/- .010	1.050	x			
1.842	+/- .010	1.840	✓			
1.34	+/- .030	1.349	x			
1.42	+/- .030	1.421	✓			
1.94	+/- .030	1.938	✓			
3.72	+/- .030	3.712	✓			
.65	+/- .030	.652	✓			
1.52	+/- .030	1.530	x			
1.60	+/- .030	1.609	✓			
2.59	+/- .030	1.605	x			
3.311	+/- .010	3.312	x			
1.326	+/- .010	1.319	✓			
5.85	+/- .030	5.851	✓			
2.95	+/- .030	2.935	✓			
1.040	+/- .010	.037	✓			

Measured by: HB	Audited by: b	Prototype Approval:
Date: 9-1-21	Date: 09.02.21	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



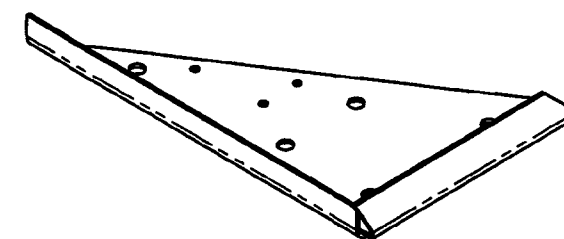
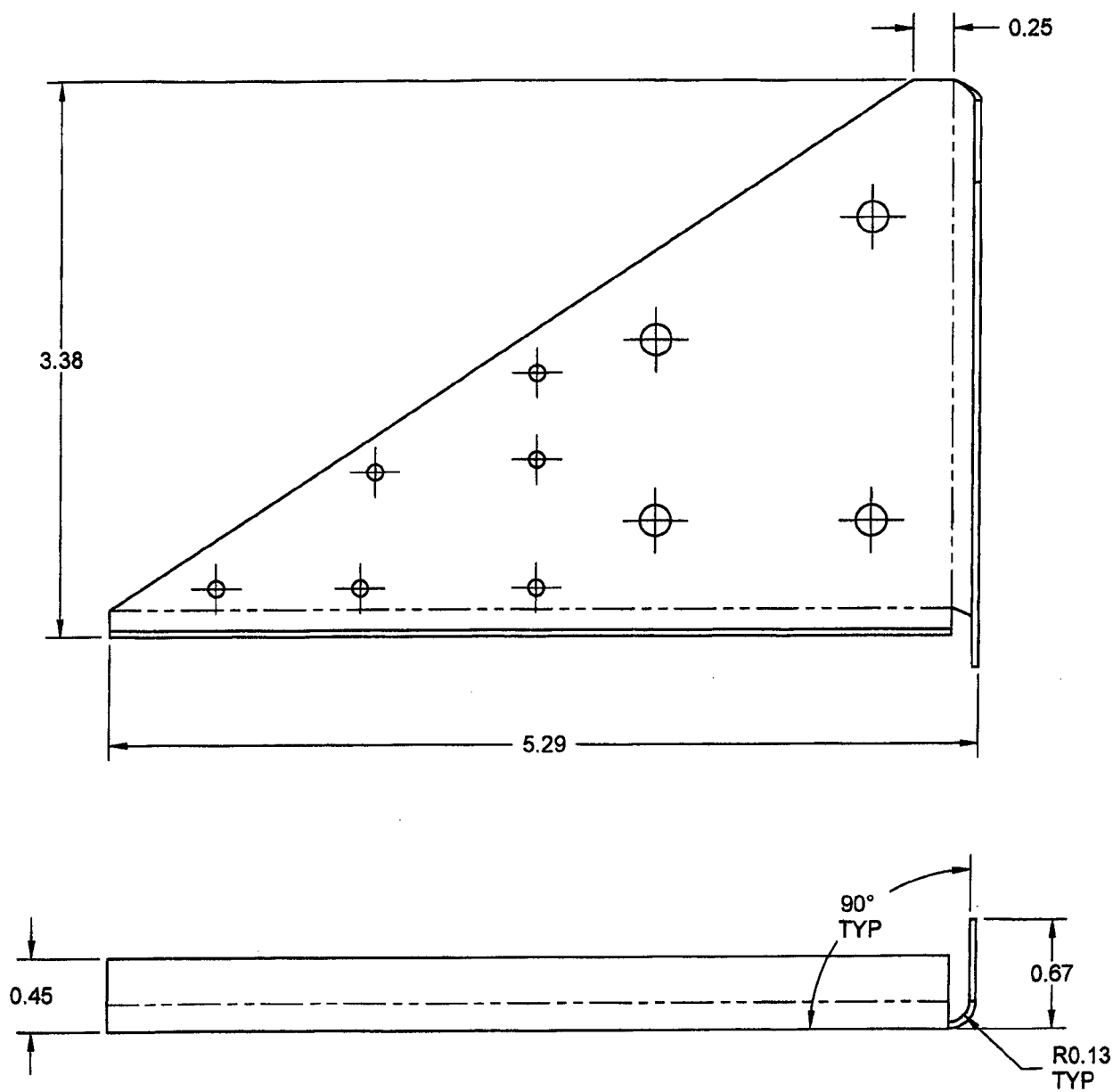
D3871-1F DOUBLER FLAT PATTERN

- NOTES:**
1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.02 lbs

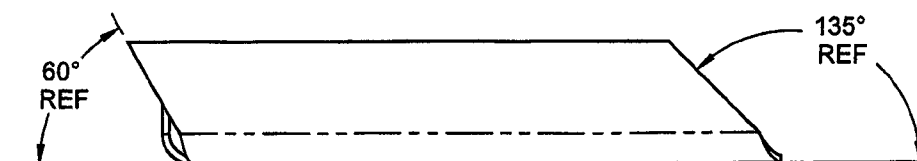
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3871	SHEET 3 OF 3
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44962

PRELIMINARY ISSUE
09/01/15



PRELIMINARY ISSUE
29/08/15



44962

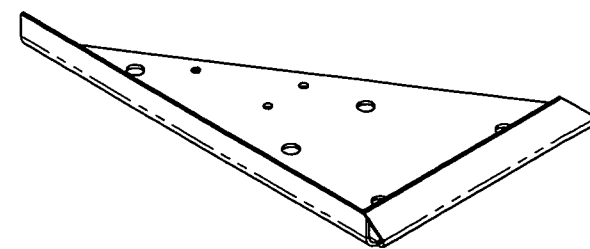
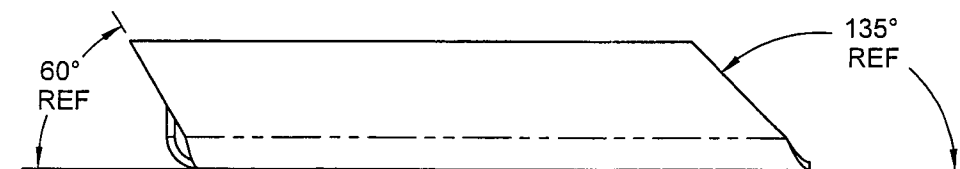
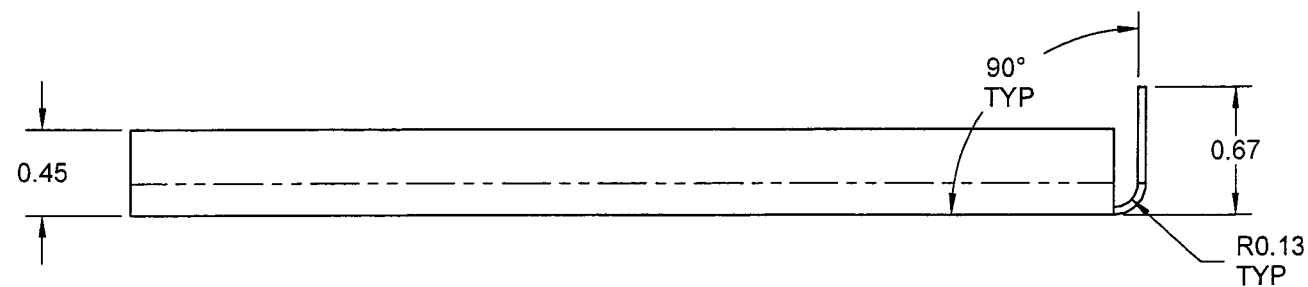
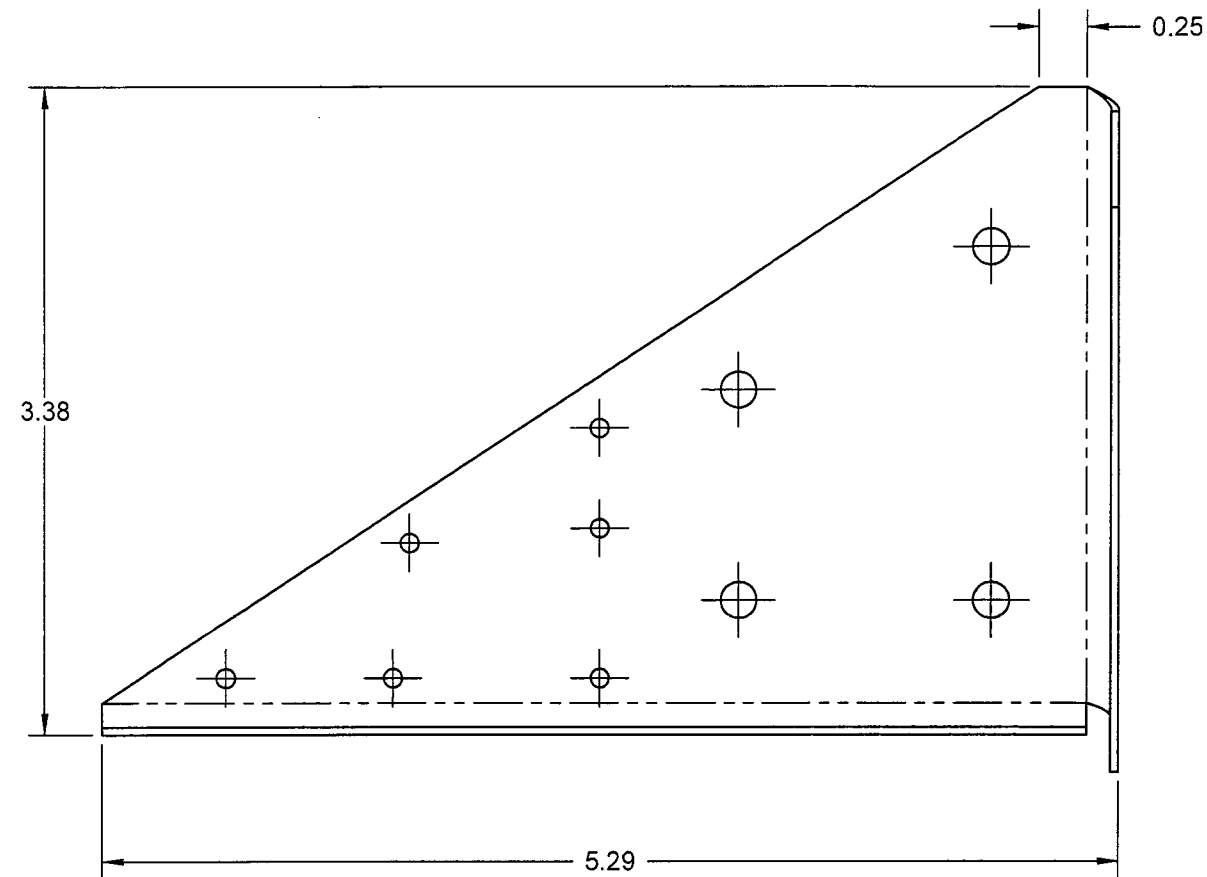
D3871-1 DOUBLER
MADE FROM D3871-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3871-1" & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.02 lbs

A	NEW ISSUE	BY	08.12.17
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
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MFG. APPR.			
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DATE	08.12.17		

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TITLE DOUBLER	SCALE NTS
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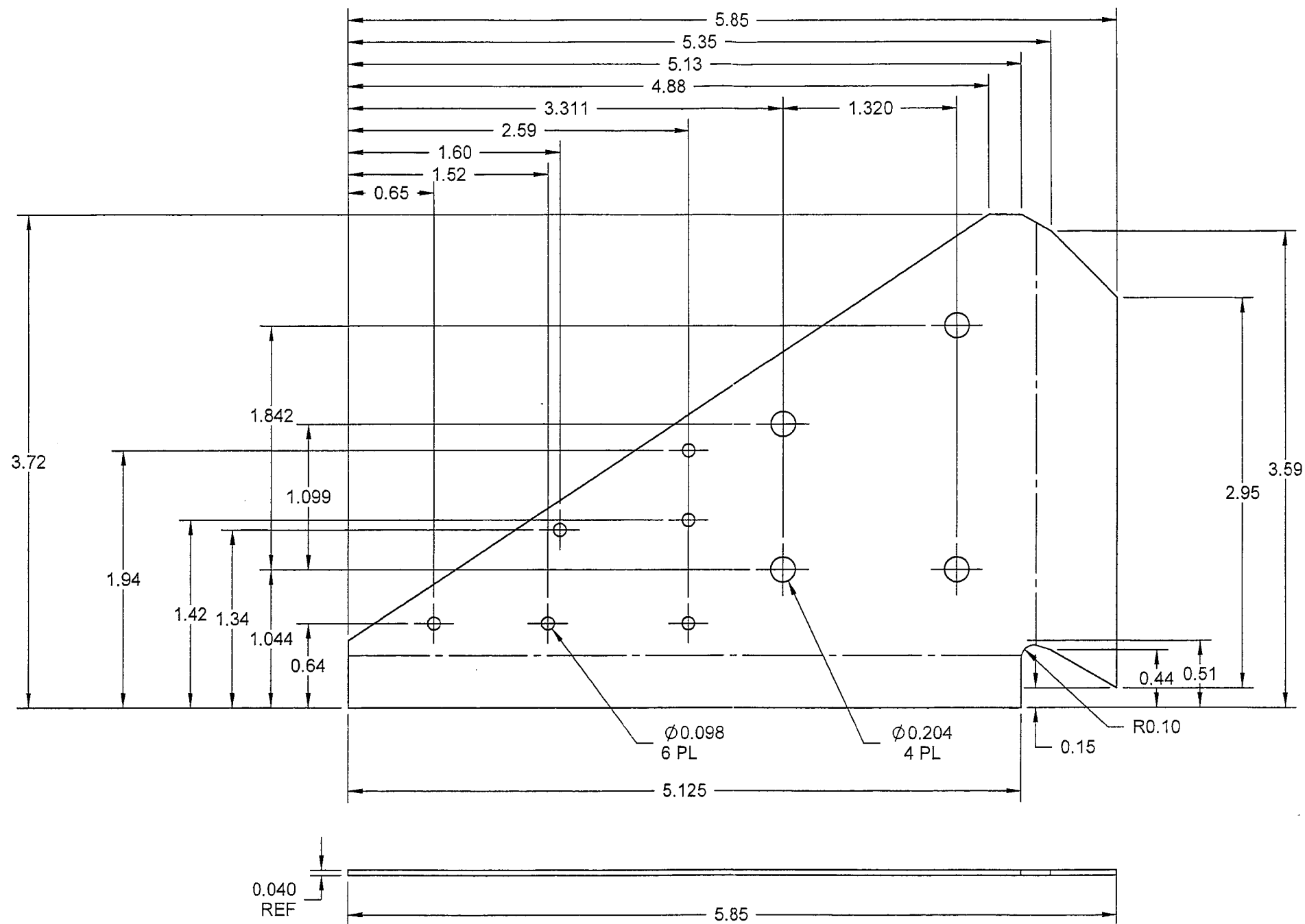


D3871-1 DOUBLER
MADE FROM D3871-1F FLAT PATTERN

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
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 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3871-1" & B/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.02 lbs

RELEASED
10/2/27

A	NEW ISSUE	BY	08.12.17
REV.	DESCRIPTION	BY	DATE
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CHECKED		DRAWING NO. D3871 REV. A SHEET 1 OF 3	
MFG. APPR.			
APPROVED		TITLE DOUBLER SCALE NTS	
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MFG. APPR.		D3871	SHEET 3 OF 3
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